

Work Order ID 57515

April 8, 2010 7:19:45 AM



Page 1

Item ID: D2282-043

Accept



Setup Start



Revision ID:

Item Name: Saddle Assembly

Stop



Start Date: 4/08/10 Start Qty: 20.00



Cust Item ID:

Required Date: 4/22/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2282

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per D2282-043 Saddle Assembly

A/RER316L SS

Filling Rod

Dwg Rev: E

20

PD 10.01.26

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Rough grind and brown pad to grind weld, take all welding marks out and

debur holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***

2-Tumble

20

PD 10.04.27

20

PD 10-4-29

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

6/10-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57515

April 8, 2010 7:19:46 AM



Page 2

Item ID: D2282-043

Accept



Setup Start



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Item Name: Saddle Assembly

Stop



Start Date: 4/08/10 Start Qty: 20.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

5 w/ops

counted
(420)

160

Identify as per dwg & Stock Location:

CA

0.00



Packaging

Memo

0.00

Packaging

9/5/05/13 *(20)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/13
MF
110-5-13

W/O:		WORK ORDER CHANGES						
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Picklist Print

April 8, 2010 7:19:45 AM

Page 1

Work Order ID: 57515

Parent Item: D2282-043

Parent Item Name: Saddle Assembly

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Start Date: 4/08/10

Required Date: 4/22/10

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2281		Manufactured	No			100	Each	38.0000	20.0000			
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Jack Saddle



PD 10.04.23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

38

56687

38

D2282-7

Manufactured No

100 Each

122.0000 40.0000



Tube



20

PD 10.04.23

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

122

48283

33

56690

89

32

8

W/O:		WORK ORDER CHANGES						
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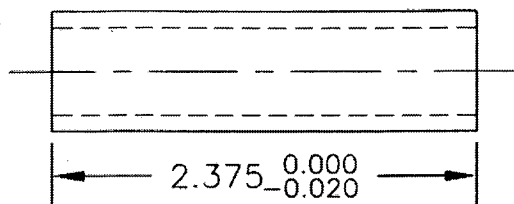
NOTE: Date & initial all entries



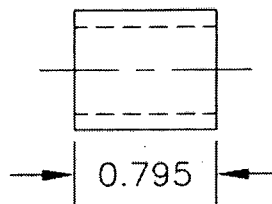
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED
[Signature]

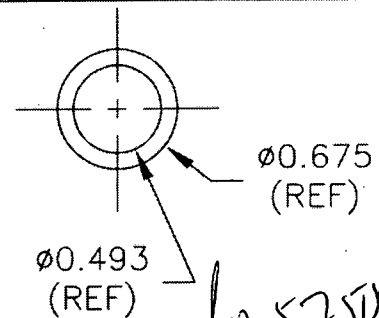
05/09/16



D2282-3



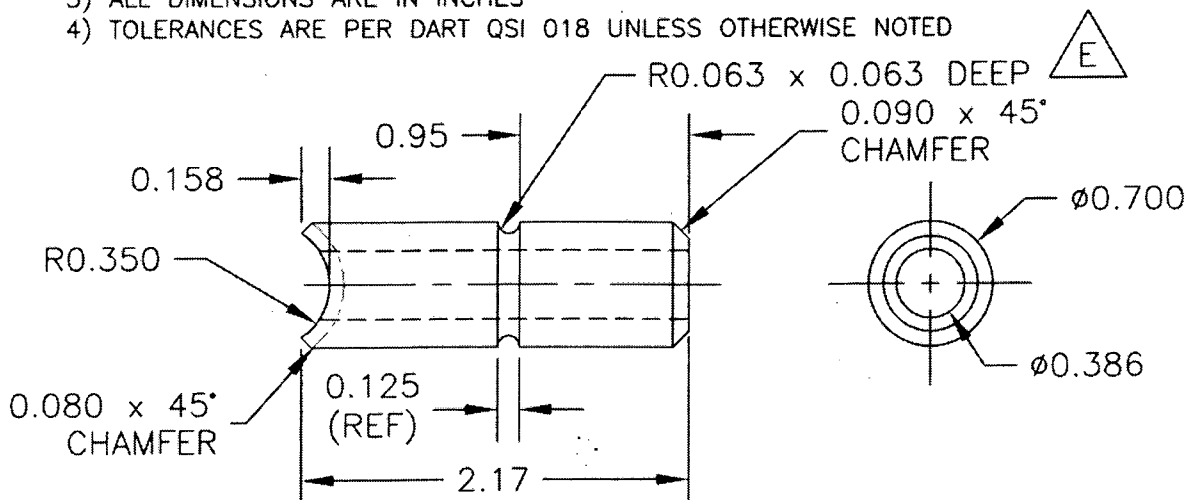
D2282-7



WLO 575R

D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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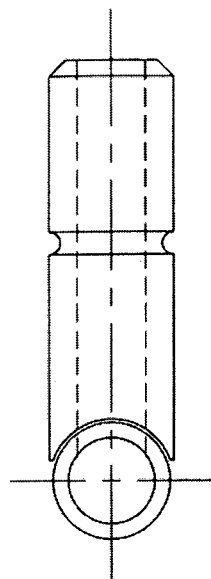
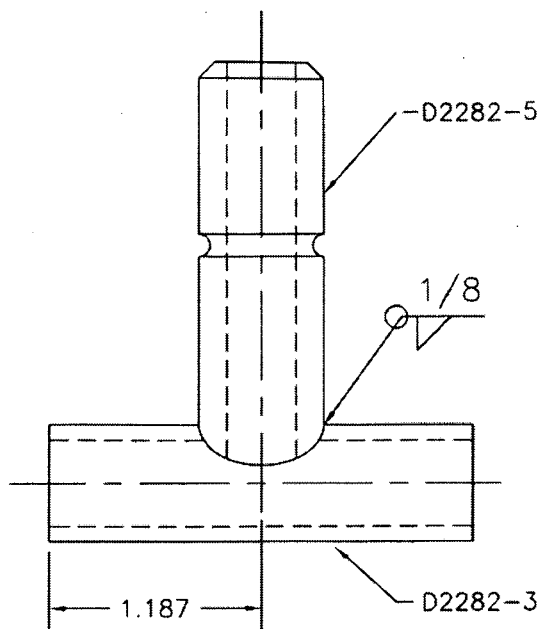
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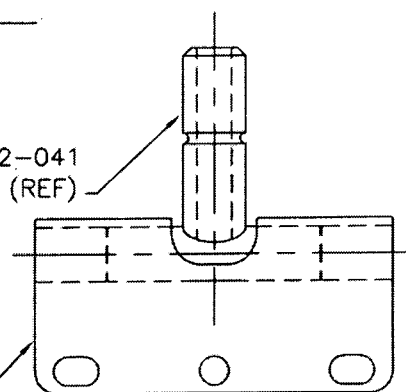
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

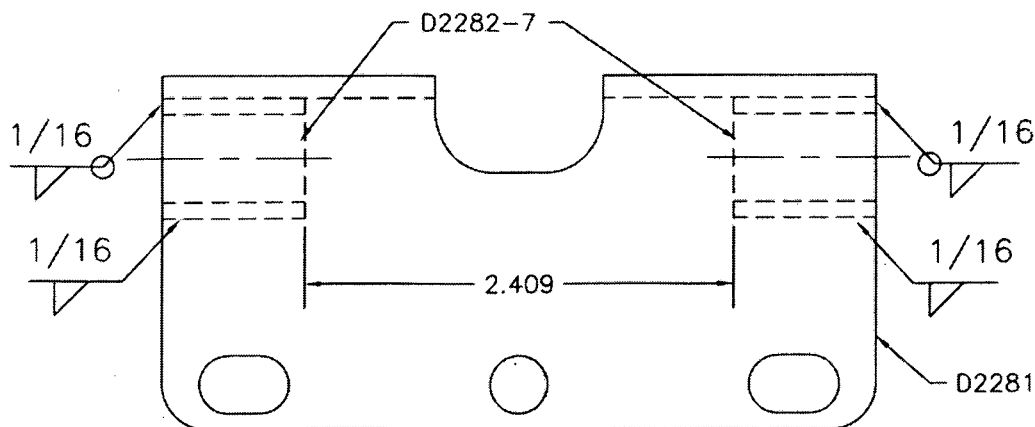


D2282-041
(REF)



D2282-043
(REF)

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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